

SHIP MAR-22

SOLD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4165-1

Job Sheet 172721



Part No: D4165-1

Job Qty: 6 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/8/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV B SHEET 1 IPP Rev:A 11.03.09 new issue DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		3/7/18	0.00	0.00	Start Up Waterjet		dc 18/03/01
100	Waterjet	6 pcs		3/7/18	0.02	0.88	Waterjet1		dc 18/03/01
120	QC	6 pcs		3/7/18	0.00	0.00	QC8		r 2/5
130	HandFinish	6 pcs		3/8/18	0.00	0.45	HandFinish1		SA PAS-3-06
135	QC	6 pcs		3/8/18	0.00	0.00	QC7-3		11 MAR 06 2018
140	Packaging	6 pcs		3/8/18	0.00	0.00	Packaging3	5/23/18 MAR 06 2018	
150	QC21-SA	6 Ea		3/8/18	0.00	0.00	QC21		DAS 21 MAR 07 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	2.1180 sf (.353 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	2	91	0



Container No: S046795

Part: D4165-1

Job No: 172721

Serial No/Batch: S046795

Revision:
Inspector:

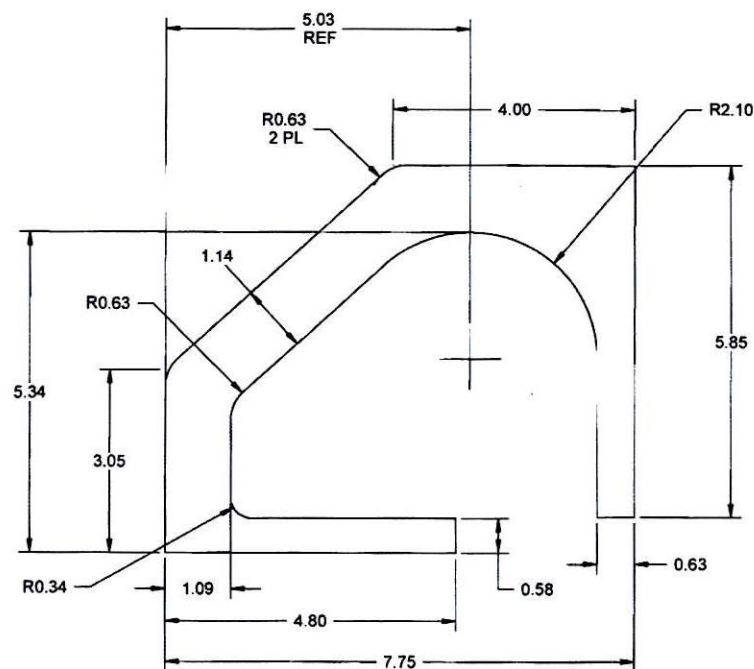
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Date: 03/01/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	5.340Inches $\pm$ 0.030	5.370 5.310		
2	Doubler	3.050Inches $\pm$ 0.030	3.080 3.020		
3	Doubler	1.090Inches $\pm$ 0.030	1.120 1.060		
4	Doubler	4.800Inches $\pm$ 0.030	4.830 4.770		
5	Doubler	7.750Inches $\pm$ 0.030	7.780 7.720		
6	Doubler	0.580Inches $\pm$ 0.030	0.610 0.550		
7	Doubler	0.630Inches $\pm$ 0.030	0.660 0.600		
8	Doubler	5.850Inches $\pm$ 0.030	5.880 5.820		
9	Doubler	4.000Inches $\pm$ 0.030	4.030 3.970		
10	Doubler	5.030Inches $\pm$ 0.030	5.060 5.000		
11	Doubler	0.040Inches $\pm$ 0.010	0.050 0.030		

Plex 2/21/18 1:54 PM dart.logan.david

Job 172721



D4165-1 DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

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NO. 172 721

20180221

RELEASED
2011-04-15

B	CORRECTED BEND ORIENTATION ON D4165-9 (ZN C1-5)	RF	11.04.11
A	NEW ISSUE	RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4165	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	VRD PARTS	NTS
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